

Date: Thursday, 9/14/2006 1:08:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET	
Job Number	: 28598		Part Number	: D3046041	
Estimate Number	: 10364		Drawing Number	: D3046 REV. A <i>UNDER REVIEW</i>	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/14/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/25/2006 Qty: 6 Um: Each	
Previous Run	: 28435			<i>M. Johnston</i> 09.09.14	
Written By					
Checked & Approved By					
Comment	: Est: A 01.08.20 New issue SM/EC				

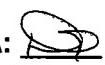
Additional Product

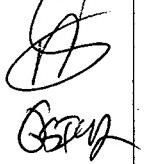
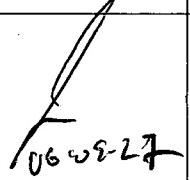
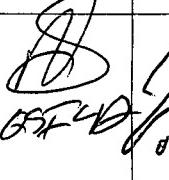
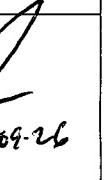
Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D30461	Lug Bracket			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)			<i>B 28598 ④ X1</i>
		LUG BRACKET			
		Qty Part Number	Description	Batch	<i>3284460 ①</i>
		1 D3046-1	Lug Bracket		<i>B 27196 ①</i>
2.0	D30463	Lug Bracket			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)			
		LUG BRACKET			
		Pick:			
		Qty Part Number	Description	Batch	
		1 D3046-3 (Bell P/N: 206-052-106-1)	Lug Bracket	N/A	
			Return Authorization #		<i>PTN SIS (28598)</i>
			Bell original batch#		<i>F2930-1/N8388/P4047/P2935/2936/P2935</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
		Comment: SMALL & MEDIUM FAB RESOURCE 1			<i>FJ 06-09-26</i>
		1- Tranfer drill holes from D3046-3 into D3046-1 as per Dwg D3046			
		2- Counter sink inside holes of D3046-1 as per Dwg D3046			<i>SAO 06:09:26 6</i>
		3- Deburr			
4.0	MS20426AD57	Rivet			
		Comment: Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s)			
		Rivet			
		Qty Part Number	Description	Batch	
		10 MS20426AD5-7	Rivet		<i>M 7681</i>
					<i>SBS 06/09/27 6</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/09/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/26	3	I part was scrap countersink to deep	 	Scrap + Replee	SP 06/09/26	 06/09/26	 06/09/26	 06/09/26

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SPS 06/09/27 ⑥

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QC5 06-09-27 6

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Q.M.

06-09-28

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06 09 28 ⑥

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

C

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/09/28

Job Completion



u 06-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

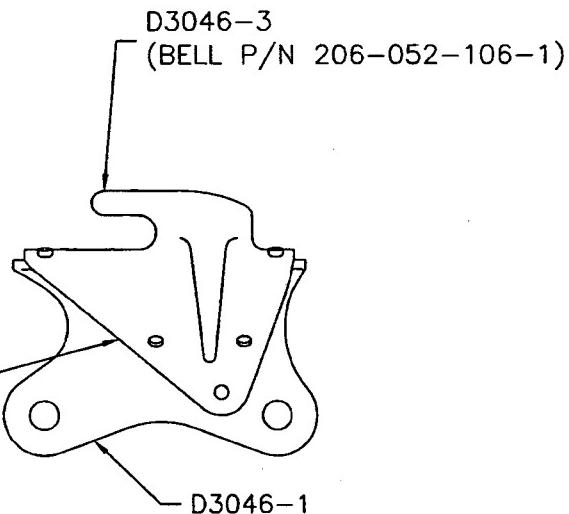
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3046	SHEET 1 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2
A	01.08.23	NEW ISSUE	



TRANSFER DRILL Ø0.156 HOLES
FROM D3046-3 TO D3046-1.
C'SINK Ø0.286 x 100°.
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)

CENTER D3046-3
ON D3046-1

D3046-041 LUG BRACKET ASSEMBLY

NOTES:

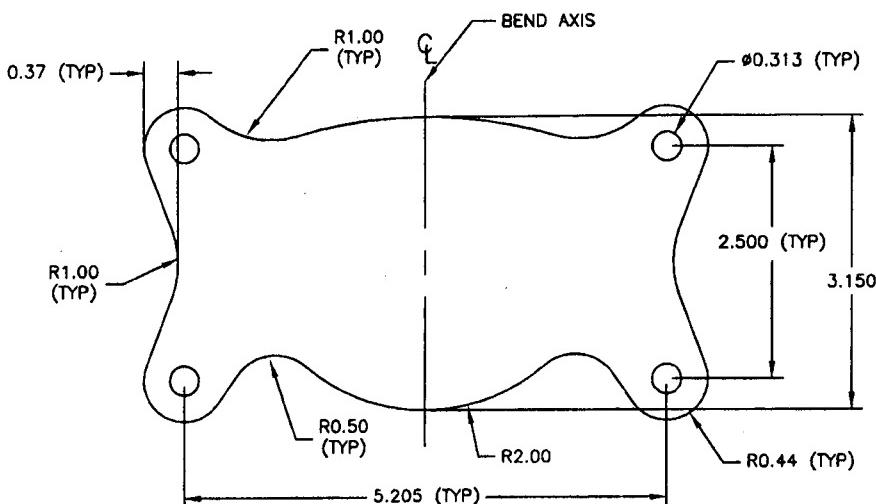
- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OR REVIEW
NO 28598

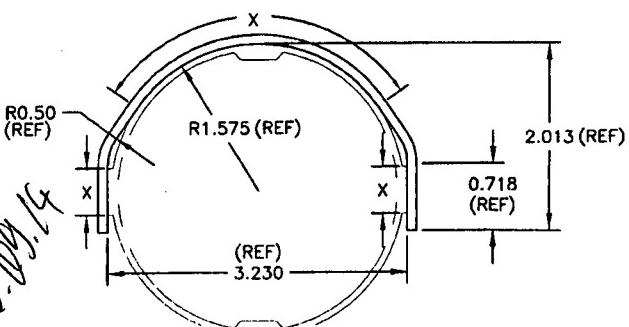
UNDER REVIEW
John
RELEASED 06.09.14
R
a.08-27

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3046	SHEET 2 OF 2
DATE	TITLE	SCALE	
01.08.23	LUG BRACKET	1:2	



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (Q)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

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WITHOUT NOTICE

WORK ORDER
NO. 28598

RELEASED
01.08.27

UNDER REVIEW
06.09.16

GENERAL NOTES
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES